

Date: Friday, 14/11/2008 9:15:16 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLIDING DOOR BRACKET-NO SLOTS  
Job Number : 43441  
Estimate Number : 13643  
P.O. Number :  
This Issue : 14/11/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D36753  
First Issue : / / Type : SMALL / MED FAB Drawing Number : D3675 REV D PRELIM B  
Previous Run : 43440 Material :  
Written By : Due Date : 17/11/2008 Qty: 2 Um: Each  
Checked & Approved By :  
Comment : Est Rev:A new issue 08-11-06 EC verified by:DD

POSITIVE  
RECALL

Additional Product

Job Number:



PRELIMINARY ISSUE

RELEASED  
# 01.10.25

Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



MAT NOT PULLED



Comment: Qty.: 0.1271 sf(s)/Unit Total : 0.2541 sf(s)  
304 stainless steel 0.032" Sheet  
Batch: 109657 HB 8-11-17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D3675  
Dwg Rev: PRE-2 HB 8-11-17  
Prog Rev: PRE-2  
2-Deburr if necessary HB 8-11-17

3

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-11-17



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



10811-18 3



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Form as per Dwg D3675

SB 08/11/19

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 14/11/2008 9:15:16 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET-NO SLOTS

Job Number: 43441

Part Number: D36753

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-19 (3)

7.0

POWDER COATING

POWDER COATING



M106442



(3x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45  
320 OF  
2:15

MF 08/11/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-19

(3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(3)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 240

8/11/25

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/25

Job Completion



POSITIVE RECALL  
EFFECTIVE 08-11-14  
RELEASED 08-11-25  
AUTH 11  
DATE 08-11-25

NO SLOTS ARE ACCEPTABLE  
- FOR CUSTOMER TRIAL  
AND FEEDBACK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

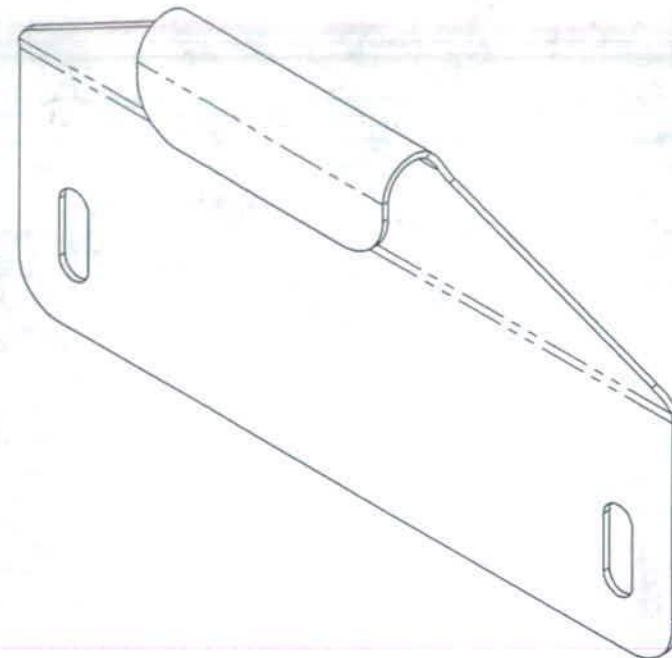
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

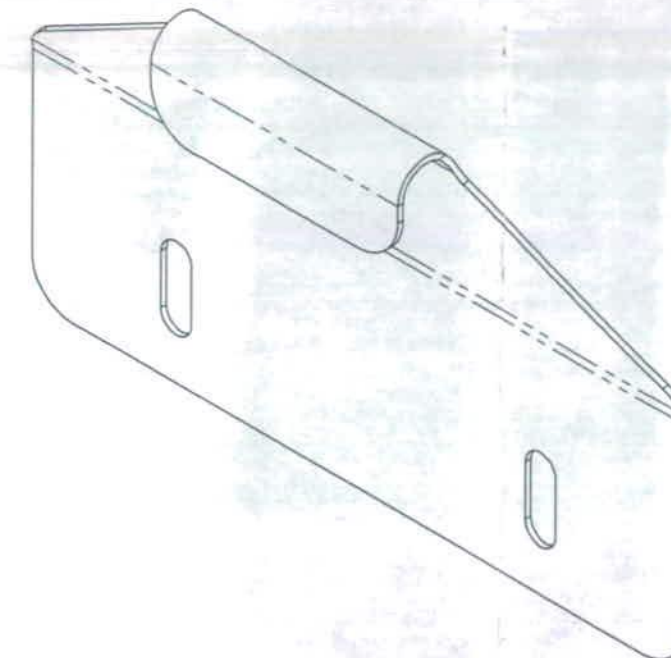
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3675-1 SLIDING DOOR BRACKET**



**D3675-3 SLIDING DOOR BRACKET**  
(HINGE PANEL MOD)

**PRELIMINARY  
ISSUE**

*ASS 08.11.04*

*43441*

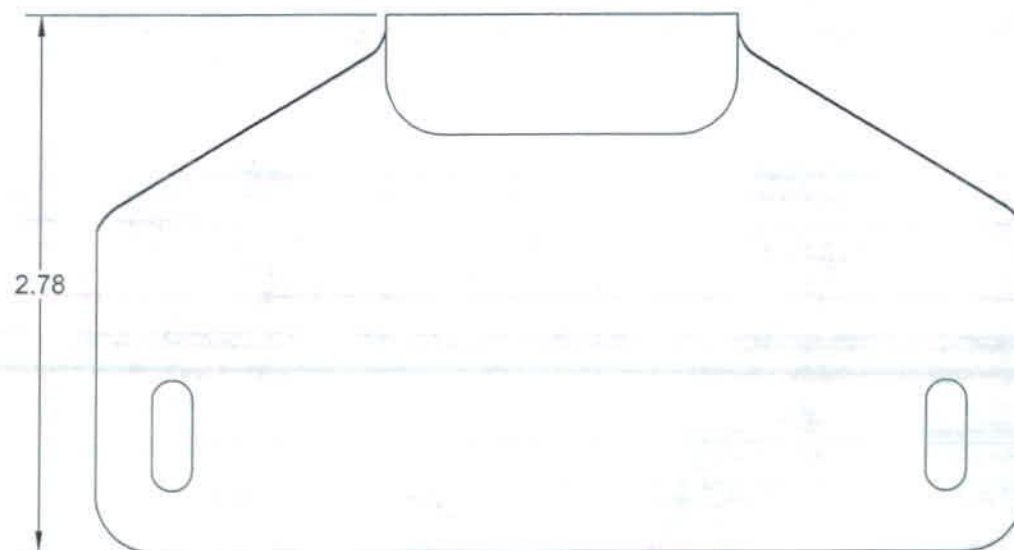
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED)  
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

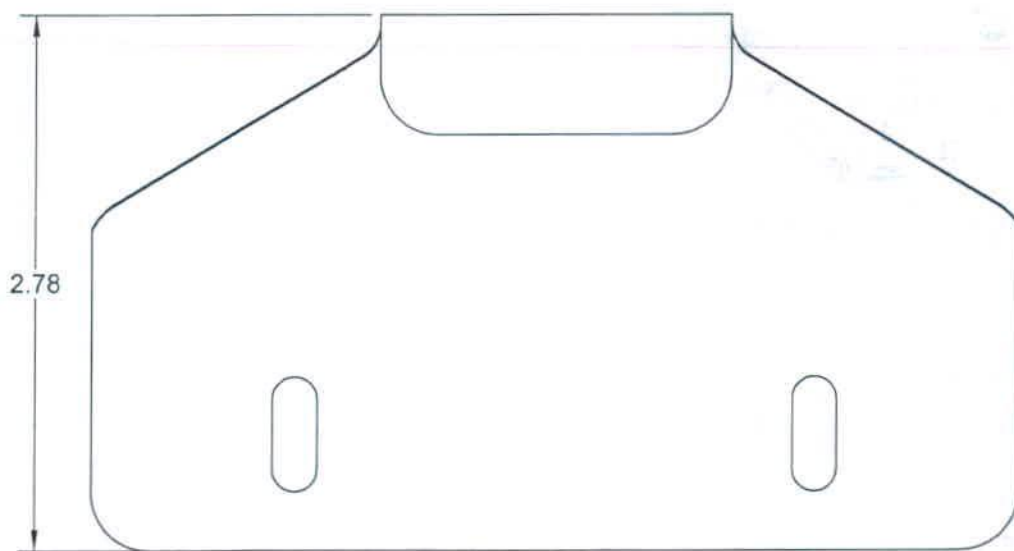
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A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



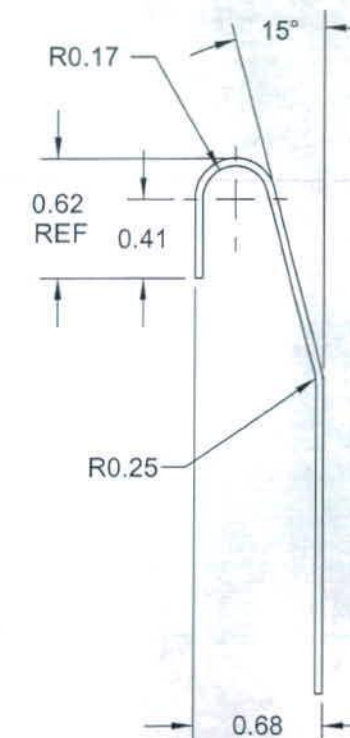
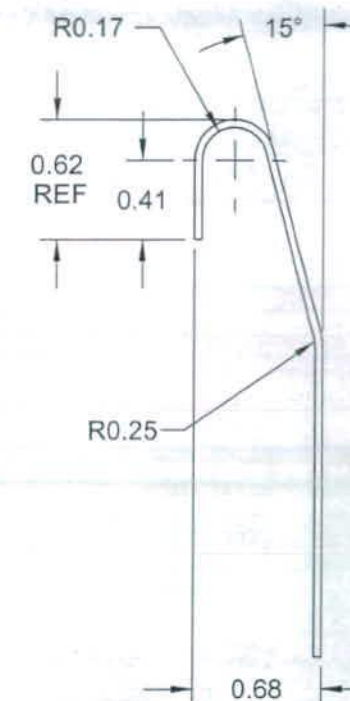




**D3675-1 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-1F)



**D3675-3 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-3F)  
(HINGE PANEL MOD)



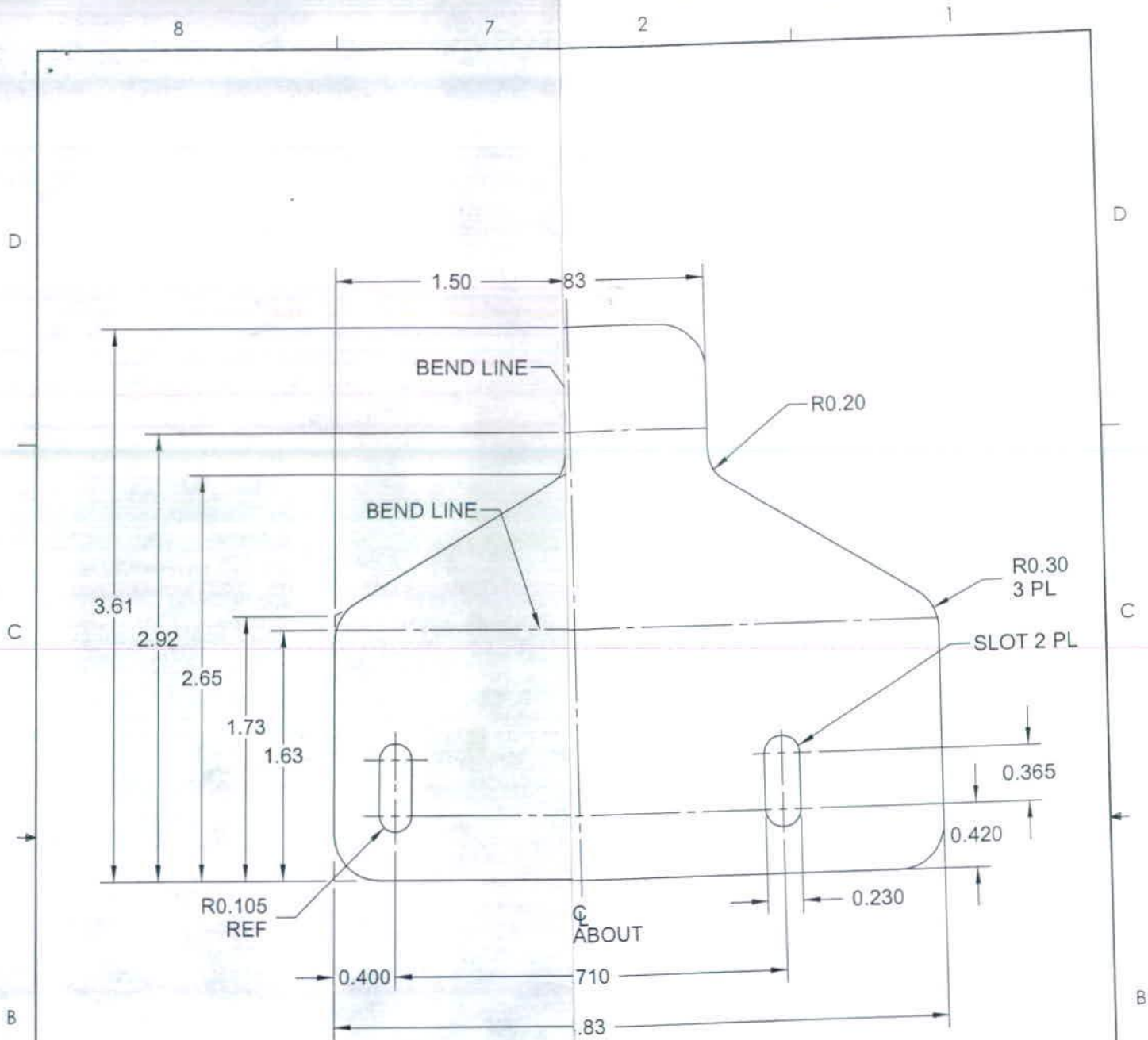
**PRELIMINARY  
ISSUE**  
AS 08.11.04

Wb 43441

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 2 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	08.11.03		NTS
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**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D3675**

REV. B  
SHEET 3 OF 3

TITLE **SLIDING DOOR BRACKET  
(COMPOSITE DOOR)**

SCALE  
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*W643441*



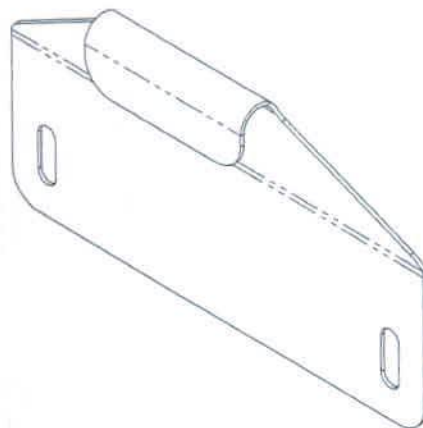
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 43441
<b>Description:</b> SLIDING DOOR BRACKET NO HOLES	<b>Part Number:</b> D3675-3 NO HOLES
<b>Inspection Dwg:</b> D3675-3, <b>Rev:</b> PRE-L.	Page 1 of 1

**X First Article**[illegible]

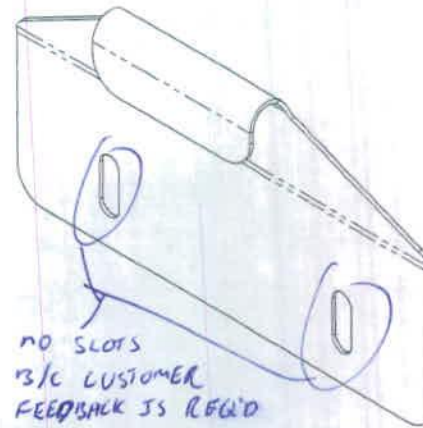
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	







**D3675-1 SLIDING DOOR BRACKET**



**D3675-3 SLIDING DOOR BRACKET  
(HINGE PANEL MOD)**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED)  
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

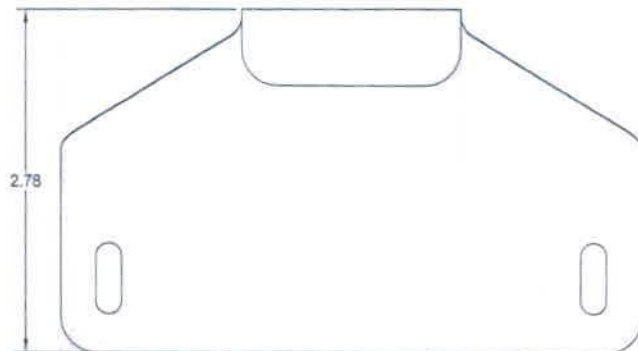
**RELEASED**  
08/11/10

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A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	AJS	D3675	SHEET 1 OF 3
APPROVED	AJS	TITLE	SLIDING DOOR BRACKET
DE APPR.	AJS	(COMPOSITE DOOR)	SCALE
DATE	08.11.03	NTS	

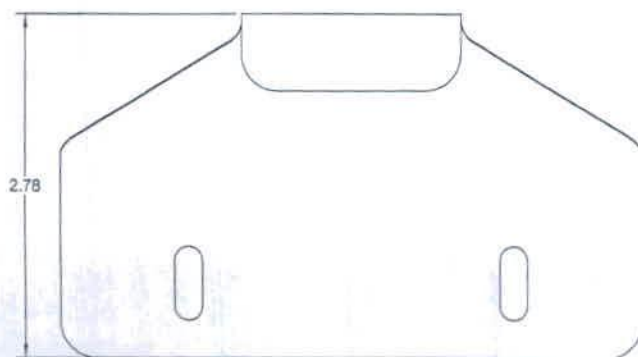
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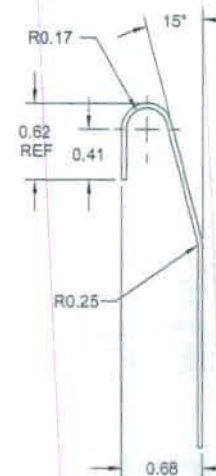
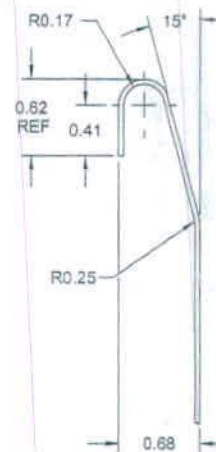




**D3675-1 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-1F)



**D3675-3 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-3F)  
(HINGE PANEL MOD)



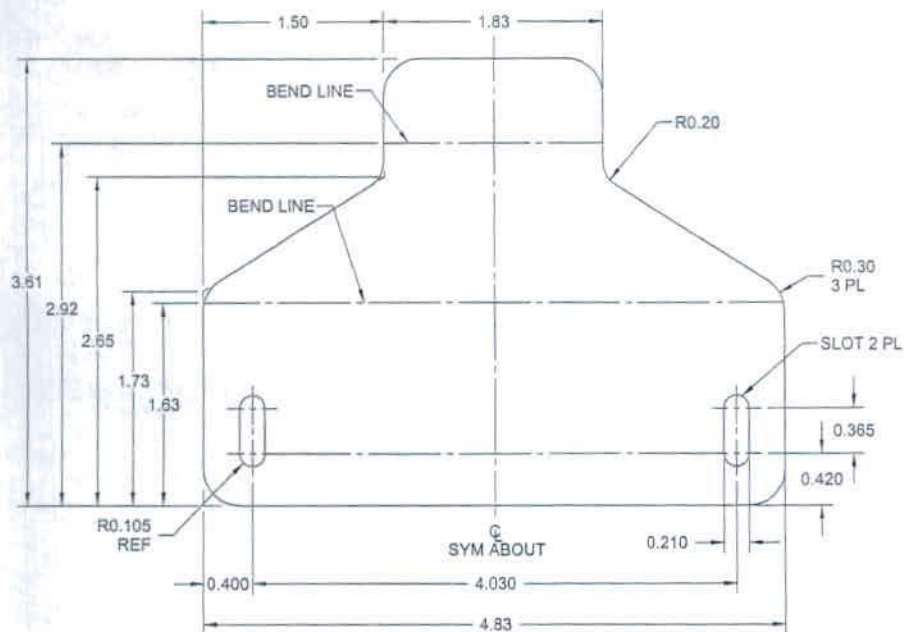
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DRAWN	AJS		
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MFG. APPR.		D3675	SHEET 2 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	08.11.03		NTS

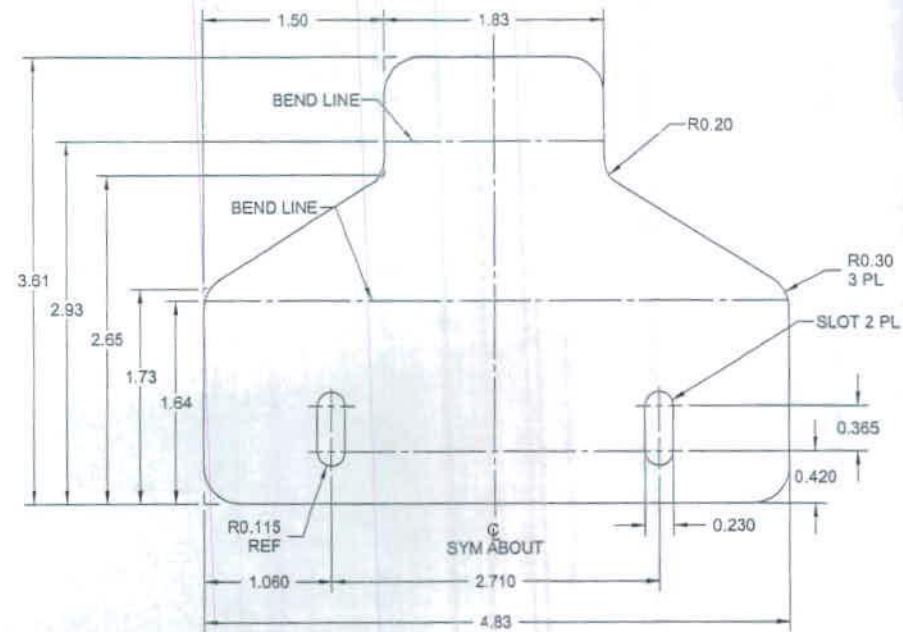
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mo 43441





**D3675-1F FLAT PATTERN**



**D3675-3F FLAT PATTERN**

*W043444*

RELEASED  
08-11-03

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CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3675</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE <b>SLIDING DOOR BRACKET (COMPOSITE DOOR)</b>	SCALE
DE APPR.	<i>[Signature]</i>	NTS	
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